

Work Order ID 50273

July 14, 2009 1:01:32 PM



Page 1

Item ID: D3144-109

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

400

Start Date: 7/15/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-07-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3144	Rev C

100



PURCHASING

Waterjet

Memo

0.00

0.00

09 08 920 (4)

FLOW CNC Waterjet

I-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

09 08 00 (4)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

Work Order ID 50273

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Page 2

Item ID: D3144-109

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Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00
u | 7 S

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

09-08-20
⇒ 44

(x4)

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50273

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Item ID: D3144-109

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

11109091

Memo

START TIME: 7:50 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:20 AM

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

(X4) φ

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

PL 09-08-24

(4).

170



Packaging

Packaging

Identify as per dwg & Stock Location: CA

0.00

Memo

0.00

PL 09-08-24
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50273

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Item ID: D3144-109

Accept

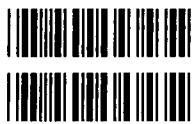


Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 7/15/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

180



QC21- Final Inspection - Work Order Release

QC

Quality Control

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

09/08/25 HJ

C 09/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

~NOTE: Date & initial all entries

Picklist Print

July 14, 2009 1:01:32 PM

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Work Order ID: 50273



Parent Item: D3144-109RevC



Parent Item Name: Doubler

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3144-109FRevC Doubler		Purchased		No		100	Each	0.0000	2.0000			B#106270 (Mat)

112024T3 S.032 2SF

08/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

~NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50273
Description: DOUBLER	Part Number:	D3144-109
Inspection Dwg: D3144 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

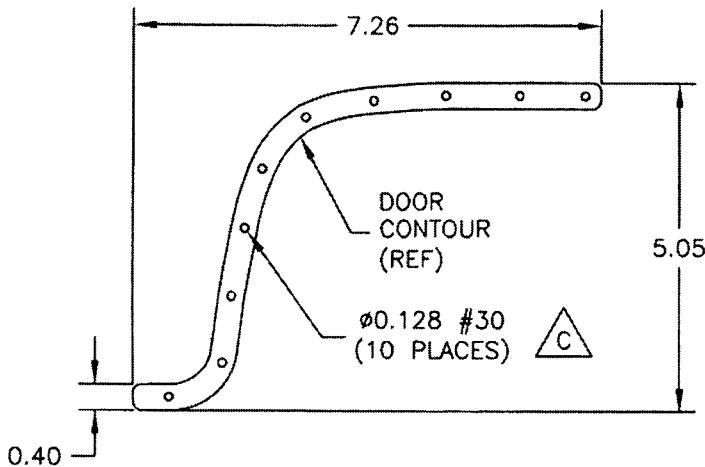
X First Article Prototype

Measured by:	<i>Mr. M/</i>	Audited by:	<i>S/</i>	Prototype Approval:	<i>1/</i>
Date:	09.08.20	Date:	09/08/20	Date:	1/4

Rev	Date	Change	Revised by	Approved
A	..	New Issue	KJ/JLM	

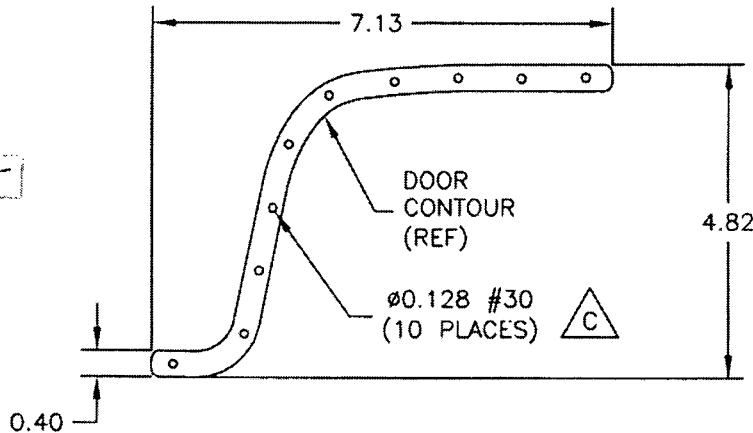
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3144	REV. C SHEET 8 OF 9
DATE 05.10.19		TITLE DOUBLER	SCALE NTS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 50273

mf
09-07-15



RELEASED
05.11.14 *ff*

D3144-109/-115 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C8.DWG"

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